



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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RBE703A94-1130-01-13
Job Sheet 184010



Part No: RBE703A94-1130-01-13

Job Qty: 12 ea 16

DAS
21
9-89

Part Name: Compression Spring Ø1.25mm x 11.25mm OD x 44.5mm



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/1/18

Job Tracking No:

Due Date: 10/22/18

Created By: Logan David

Type: Stock

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev.A 17.08.09 New issue DP Verify DD/IPP Rev B 17.11. 30 DWG RBE703A94-1130-01 Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		10/22/18	0.00	0.00	Start Up Small Fab-2		MCC
110	Small Fab	12 pcs		10/22/18	0.00	2.40	Small Fab-3		MCC DAS
120	QC	12 pcs		10/22/18	0.00	0.00	QC5		OCT 04 2018 68
130	Packaging	12 pcs		10/22/18	0.00	0.00	Packaging3-1		MCC 9-89
140	QC21-SA	12 Ea		10/22/18	0.00	0.00	QC21		DAS OCT 05 2018

Part Op 110 - Cut to length as per DWG.
Descriptions:

21
GAS 33

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
94125K815	Compression Spring Ø1.25mm x 11.25mm OD x 44.5mm	12 Ea (1 ea)	90-Start up Operation	3 x 504326 13 x 5059523

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	94125K815	12	16	0

Part Specifications

Specifications could not be found.



Dart Aerospace Ltd.
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Plex 10/1/18 1:22 PM dart.logan.david

Container No: S115737



Part: RBE703A94-1130-01-13

Job No: 184010

Serial No/Batch: S115737

Revision: K

Inspector:

Exp Date:

Instructions:

Date: 10/03/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

8 7 6 5 4 3 2 1

D

D

C

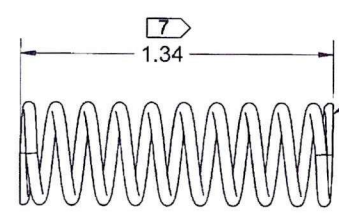
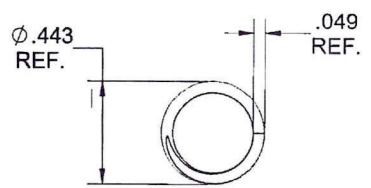
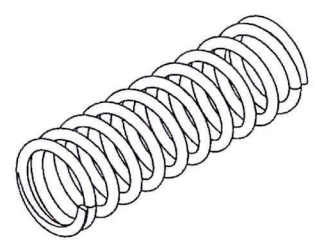
C

B

B

A

A



FLAT GROUND END
NOT REQUIRED ON
THIS END

RBE703A94-1130-01-13 COMPRESSION SPRING $\phi 1.25\text{mm}$ X 11.25mm O.D. X 44.5mm

NOTES:

- 1) MATERIAL: McMaster#94125K815
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES .015 x 45° OR .015R
- 6) IDENTIFICATION: N/A
- 7) MODIFY SPRING PIN TO THIS LENGTH

8 7 6 5 4 3 2 1

DART AEROSPACE Hawkesbury, Ontario, Canada			
TITLE COMPRESSION SPRING $\phi 1.25\text{mm}$ X 11.25mm O.D. X 44.5mm			
DWG NO.	RBE703A94-1130-01-13		REV K
DESIGN BY:	VM 8/28/2017	XXX $\pm .005$	FRACTIONS $\pm 1/8$
DRAWN BY:	VM 11/24/2017	.XX $\pm .01$	ANGLES $\pm .5^\circ$
CHECKED:	VM 11/30/2017	X $\pm .1$	SURFACES $\pm 12^\circ$
MFG. APPR:	VM 11/30/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	VM 11/30/2017	2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE:	11/24/2017	3. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE:	NTS	WEIGHT:	N/A
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															